

Envelope ship Dec 5th

Work Order ID 74936

74936

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Thursday, October 13, 2011 1:12:26 PM

Item ID: D2282-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Saddle Assembly
Start Date: 10/13/2011 Start Qty: 50.00 *50* Cust Item ID:
Required Date: 10/19/2011 Req'd Qty: 50.00 *50* Customer:
Reference:

Approvals: Process Plan: 11-10-13 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2282	Rev E

100 0.00
100 Large Fab
Large Fab Memo 0.00
Large Fab 1-Weld as per D2282-043 Saddle Assembly
A/RER316L SS Filling Rod 118194 / M115778
Dwg Rev: E

110 0.00
110 Small Fab
Small Fab Memo 0.00
Small Fab 1- Grind weld with rough pad and brown pad, take all welding marks out and
deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***

120 0.00
120 QC9- Inspect visual per QSI004- Fusion Welds
QC Memo 0.00
Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1 -Tumble								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: G-A	0.00							
160									
Packaging	Memo	0.00							
Packaging	w/o 74963								

count
 (x20)

ES 11/11/24 (50)

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

11/11/24 

R11-24
50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, October 13, 2011 1:12:35 PM

Page 1

Work Order ID: 74936

74936

Parent Item: D2282-043

D2282-043

Parent Item Name: Saddle Assembly

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2281		Manufactured	No			100	Each	67.0000	1	50			
D2281									**	B 74885 → 50x			
Jack Saddle										SJ 11/11/03			
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						WA		67					
						67539		67					
D2282-7		Manufactured	No			100	Each	134.0000	2	100			
D2282-7									**	B 74967 → 100x			
Tube										SJ 11/11/03			
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						WA		134					
						67540		134					

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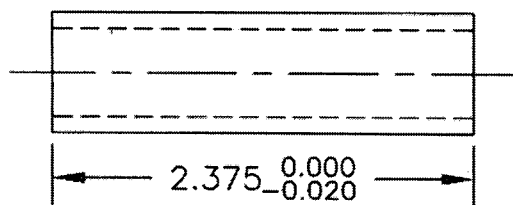
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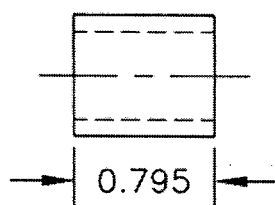


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CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

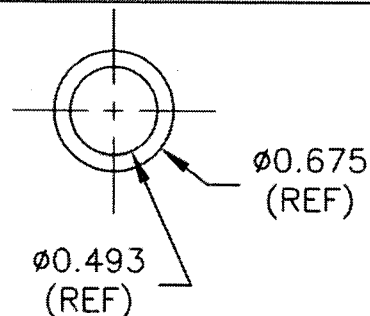
RELEASED
[Signature]
05/09/16



D2282-3

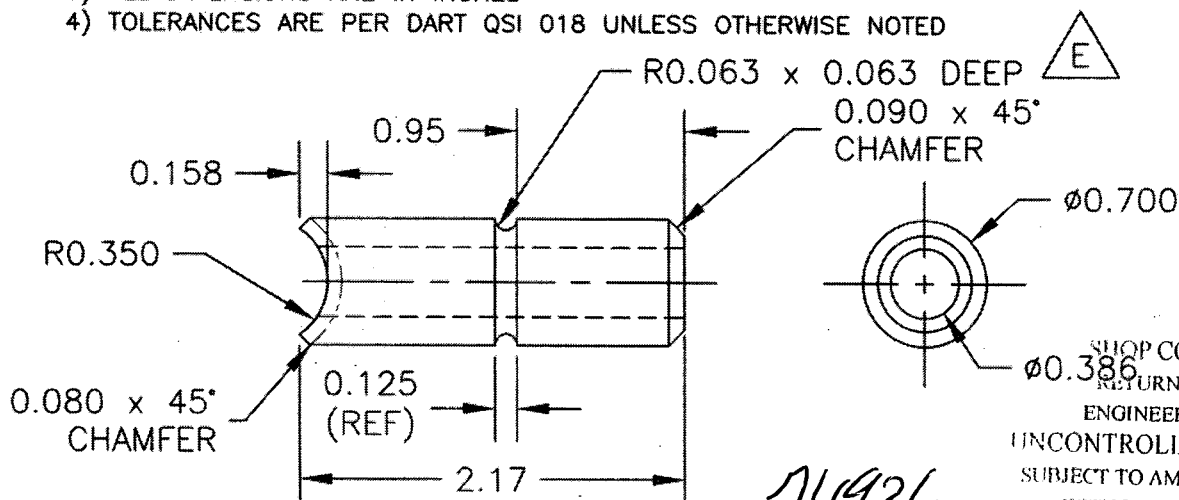


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *74769*
M.L.S.
11/10/11

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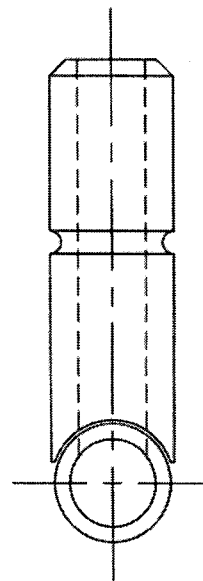
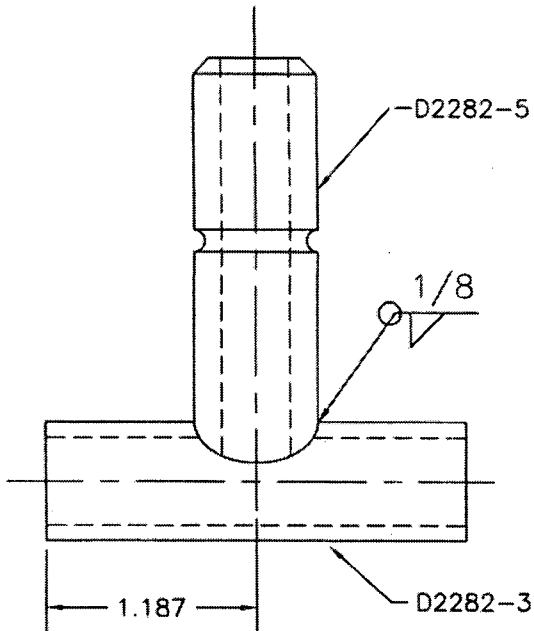
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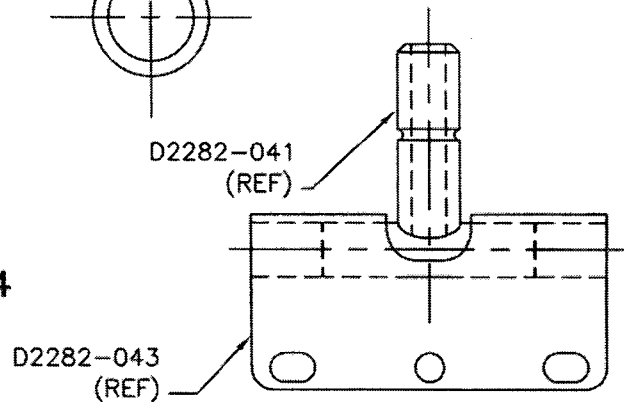


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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

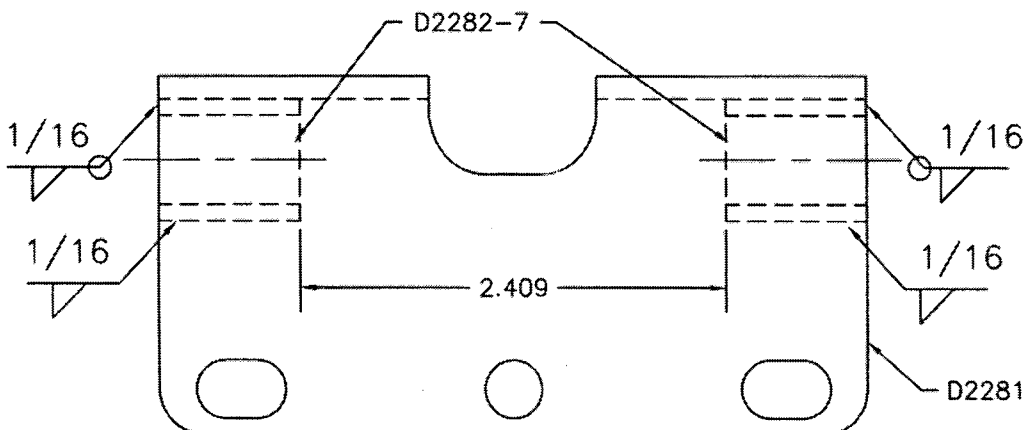


RELEASED
[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

7/1936

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